

Work Order ID 128153

January-09-15 8:10:33 AM

128153

Page 1

Item ID: D1038-58B

Revision ID:

Item Name: Avionics Fastener Rail

Start Date: 1/09/15

Start Qty: 50.00

50

Required Date: 1/23/15

Req'd Qty: 50.00

50

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D1038

Rev B

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Create white labels and bag them

110

BAND SAW

0.00

110

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

120

HAAS CNC VERTICAL MACHINING #1

0.00

120

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA783 Rev: AA & Dwg D1038 Rev: B
2-Deburr per dwg D1038

D 1038-58B
B 128153
REV. B

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run

Start

NR1

Stop

NR2

15/1/29

15/01/14

50

50

15/01/16

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Item ID: D1038-58B Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Avionics Fastener Rail
Start Date: 1/09/15 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 1/23/15 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
130						50	0		WSP 1/15/15
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
140						50	0		JFC 2015-01-16
QC	Memo	0.00							
Quality Control									
150	Small Fab	0.00							
150						50X			DAS 28 9-89 JAN 19 2015
Small Fab	Memo	0.00							
Small Fab	Deburr					50X			15/01/20 DAS 36 9-89

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Item ID: D1038-58B Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Avionics Fastener Rail
Start Date: 1/09/15 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 1/23/15 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							38 9-89
160						(50)			
QC	Memo	0.00							
Quality Control									JAN 20 2015
165		0.00							
165						(50)			15-1-21
HandFinish	Memo	0.00							
Hand Finishing	Clean rail from all marking using acid etch and scotch brite before sending to get anodize								
170	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
170									CX 15/01/26 50
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: <u>27209</u> Black Anodize as per Dwg D1038								

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Item ID: D1038-58B Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Avionics Fastener Rail
 Start Date: 1/09/15 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 1/23/15 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	Receive & Inspect for Damage & Mat'l Certs	0.00							
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180

Packaging	Memo	0.00							
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Packaging									
-----------	--	--	--	--	--	--	--	--	--

190	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

190

QC	Memo	0.00							
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Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

200	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

200

Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab									
-----------	--	--	--	--	--	--	--	--	--

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389
 Batch: **M128003**
 2-Grind wire flush and deburr
 3-Clean

50x 501501-28

50

DAS 38 9-89
 DAS 9 9-89

JAN 28 2015

50x

15/01/29

DAS 36 9-89

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Item ID: D1038-58B Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Avionics Fastener Rail
Start Date: 1/09/15 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 1/23/15 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
210									
QC	Memo	0.00							
Quality Control									
220		0.00							
220	Packaging								
Packaging	Memo	0.00							
Packaging	1-Pack each fastener rail into a cardboard tube 2-Roll Part in foam . 3-Install red cap at each end and secure with tape. 4-Apply white labels to cardboard tubes 5-Identify and Stock Location: FC/20A								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

IAN 29 2015

50 15-01-29 st

15/1/29
50 ~~15-01-29 st~~

15-1-29

Picklist Print

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Work Order ID: 128153

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Parent Item: D1038-58B

D1038-58B

Parent Item Name: Avionics Fastener Rail

Start Date: 1/09/15

Required Date: 1/23/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E 03.05.02 Reformat; Added label KJ/RF
IPP Rev:F 06-08-16 Updated Packaging Procedures JLM
IPP Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2023		Manufactured	No			110	f	452.6000	1.903	96			

D2023

Extrusion, Fastener Rail

Location

Loc Qty

Loc Code

MAT051

452.6

→ 21907

452.6

Handwritten signature and date 1/20/15
Handwritten number 96

(28153)

☒ **First Article** ☐ **Prototype**

Measured by: 		Audited by: JPL		Prototype Approval:		N/A	
Date: 15/01/15		Date: 2015-01-16		Date:		N/A	

Rev	Date	Change	Revised by	Approved
A	05.02.16	New Issue	KJ/JLM	
B	06.03.08	21.750 was 12.750, Dwg rev. changed	KJ/JLM 	

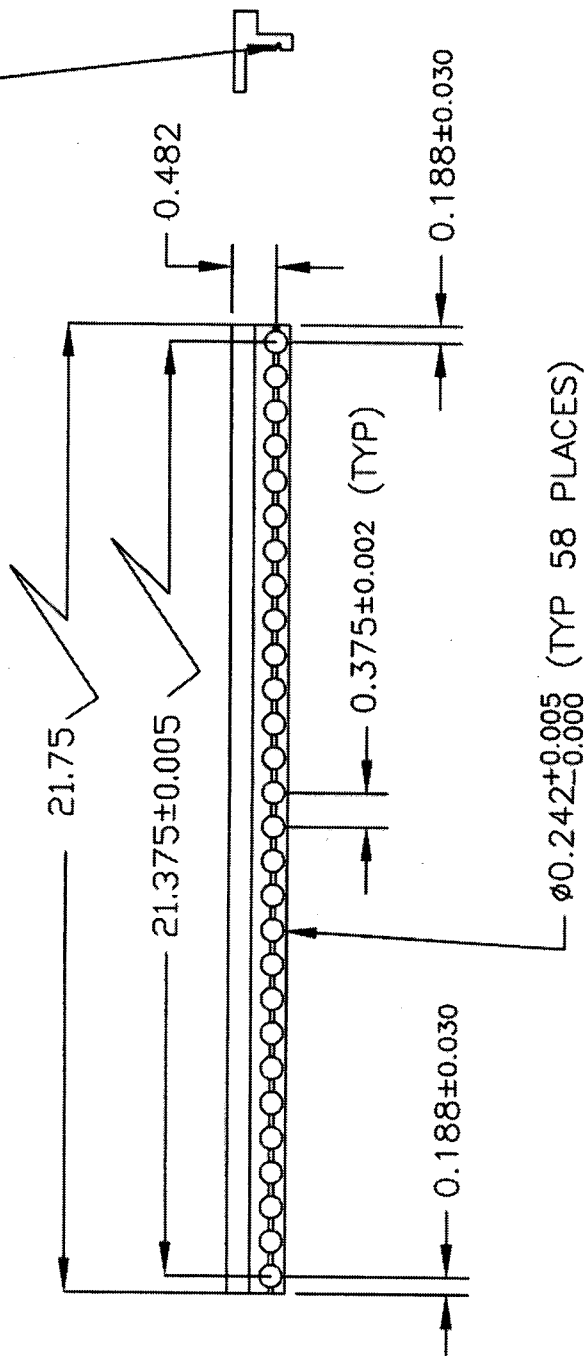
DART

DESIGN 91	DRAWN BY 91	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 91	APPROVED 91	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02		TITLE 1/4 TURN FASTENER RAIL	SCALE NTS
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED

05.03.31

STAKE, $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



D1038-58 1/4 TURN FASTENER RAIL

1) MAKE FROM D2023 EXTRUSION

2) FINISH: D1038-58 - NONE

3) ALL DIMENSIONS ARE IN INCHES

4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27209

Purchase Order Date 1/26/2015

PO Print Date 1/28/2015

Page Number 1 of 3

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-446-4544	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	VENDOR'S TRUCK	Currency	CAD
Ship Acct:		FOB	FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	128153	D1038-58B AVIONICS FASTENER RAIL REV. B	1/28/2015 Yes 1/28/2015		-50.00	\$2.75	\$137.50
FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB / IC / II / IIB CLASS 2, TYPE III CLASS 2							
NOTE: RUSH PLEASE ADVISE IF POSSIBLE TO GET FOR WEDNESDAY JAN. 28 OR BEFORE							
Line Total:							\$137.50
2	126255	D4970-3 WINDSHIELD DEFLECTOR REV. C	2/4/2015 Yes 2/4/2015		5.00	\$24.00	\$120.00
FINISH: HARD BLACK ANODIZE IAW MIL-A-8625, TYPE III, CLASS 2							
Line Total:							\$120.00

Note:

1/28/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63496

Date: 28-Jan-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms	Ship Via
Quantity	Description
50 ea	Part: D1038-58B RAIL BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150084
	Rev:
	PO: PO27209
	Line:
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>28/1/15</u> CERTIFIED SIGNATURE: <u>[Signature]</u> RECEIVER SIGNATURE: _____ <u>SP15-01-28</u>	